



## One-component paint system on steel above the waterline

### General surface preparation

#### Cleaning

Make sure that the steel surface is dry and all dirt, wax or other contamination have been removed.

#### Rust removal and sanding

Steel surface must be free of rust and mill scale. Preferably by sandblasting SA 2,5. If sandblasting is not possible, sand the entire surface manually or by machine using P60-80 dry abrasive paper. If necessary use Tercoo disc.. All welding spots/drops must be removed and sharp edges must be grinded round. Areas that are difficult to derust should be prepared with Epifanes Rust Remover.

After cleaning, derusting and sanding, apply the first (thinned) primer coat as soon as possible to ensure the least amount of renewed oxidation. The temperature of the (bare) steel must at least 3°C (41°F.) above the dew point

#### Filling

Above the waterline fill irregularities with Epifanes Epoxy Filler. After the filler has dried, sand with P180-220 dry. Apply the filler between sanded primer coats.

### One-component paint system on steel (above the waterline)

After surface preparation	Stap 1	Stap 2
Product	EPIFANES Multi Marine Primer	EPIFANES Mono-urethane Yacht paint
Number of coats	3	3
Verdunning	EPIFANES Brushthinner for Paint & Varnish	EPIFANES Brushthinner for Paint & Varnish
Percentage	5-10%	0-5%
Drying time @ 18°C.	18 hours	24 hours
Abrasive paper	P180 - 220 - dry	P400 - wet
Remarks	Attention! Thin first primer coat by 25% and apply by stiff brush. If needed, fill between primer coats with Epifanes Epoxy Filler 1500.  Apply in thin coats only. Do not use below 12°C	Thin first finishing coat by 5-10%. Always apply full finishing coats for sufficient dry film thickness.  The finish coats in step 2 may be replaced by Epifanes Yacht Enamel, Epifanes Nautiforte or Epifanes Multiforte.

**Nonskid:** For a nonskid surface continue by sanding the final gloss coat of step 2 and to apply two coats Epifanes Nonskid Deckcoating on top of the system. The underlying gloss surface will provide a waterstop. No sanding between nonskid coats.